



Work Order ID 56134

February 10, 2010 2:55:54 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

*BY*

Date: *10-2-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

*N/A*

110



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*>DP*

*10-2-18*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

120

Operation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

(X) (S) MB 10-02-22

(xj)

QC 10-02-23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID  
140Operation  
Description  
SkidtubesSet Up/  
Run Hours  
0.00Draw  
Number  
Draw  
Rev.Plan  
Code  
Accept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R□□□ Aluminum Rod

m113207

BE 10/02/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R□□□ Aluminum Rod

m113207

BE 10/02/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.  
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr



BE 10/02/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S. wclz/24

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. wclz/24

0.00

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

=&gt; H 10/03/09

0.00

+RCA lading AS per 09-043

Memo

PAR

(K)

(X) Q

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

180

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Powdercoat

Powder Coating

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC3- Inspect Part Finish

0.00

= 4/10/03/09

0.00

BK 10-3-10

0.00

QC

Quality Control

Memo

START TIME: 1:00pm

Memo

OVEN TEMPERATURE: 320°

FINISH TIME: 1:30pm

OK ✓

OK ✓

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200



HandFinish

Hand Finishing

Memo 0.00

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R   Sikaflex-291  112345 

Sikaflex expire date: 10/68

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step &amp; Aft Cap with Sikaflex. Clean excess adhesive

A/R   Sikaflex-291  112345 

Sikaflex expire date: 10/68

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 113462

J

BL 10-3-10 ,

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S wlm/m

(20)

220



Packaging

Packaging

0.00

Memo  
Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

P403/11 C

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo  
Identify and pack for shipping as per PPPD205-634-041  
Location: PPP Rev: PDP 56400

10/03/16 JG

mf

10-3-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D2580-1 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary | Last | Route<br>110 | Unit of<br>Each | Qty on<br>5.0000 | Remaining<br>1.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|------------------|---------------------|-----|------|--------|
|                               |             |                      |           |         |      |              |                 |                  |                     |     |      |        |

205 Skidtube bent detail



Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

LG  
54541 B56123 5  
54697 2  
54721 1

DP 10-2-18

D2576-3



Manufactured      No

140      Each      141.0000      1.0000



Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST  
46661 94  
52215 47

1 8E 10/24/13

Step (machining detail)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev:O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D2579 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary<br>Last | Route<br>140 | Unit of<br>Each | Qty on<br>147.0000 | Remaining<br>20.0000 | Qty | Date | Status |
|-----------------------------|-------------|----------------------|-----------|-----------------|--------------|-----------------|--------------------|----------------------|-----|------|--------|
|                             |             |                      |           |                 |              |                 |                    |                      |     |      |        |

Crossbolt Spacer



| Warehouse       | Loc Oty | Loc Code |
|-----------------|---------|----------|
| <u>Location</u> |         |          |
| Main Warehouse  |         |          |
| LG              | 25      |          |
| 51525           | 4       |          |
| 53780           | 3       |          |
| 54543           | 18      |          |
| Main Warehouse  |         |          |
| ST              | 122     |          |
| 43988           | 4       |          |
| 46434           | 4       |          |
| 46956           | 2       |          |
| 47797           | 9       |          |
| 48272           | 2       |          |
| 51314           | 71      |          |
| 51315           | 30      |          |

B56145

20

BE 10/02/23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D2855 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary | Last | Route<br>200 | Unit of<br>Each | Qty on<br>151.0000 | Remaining<br>1.0000 | Qty | Date | Status |
|-----------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|--------------------|---------------------|-----|------|--------|
| Cap                         |             |                      |           |         |      |              |                 |                    |                     |     |      |        |

## Warehouse Loc Qty Loc Code

### Location

#### Main Warehouse

|       |     |
|-------|-----|
| ST026 | 151 |
| 50513 | 1   |
| 50770 | 1   |
| 51539 | 39  |
| 53791 | 110 |

## Loc Qty

## Loc Code

1 BL10-3-10

AN3-5A

Purchased No

2.0000

## Warehouse Loc Qty Loc Code

### Location

#### Main Warehouse

|        |      |
|--------|------|
| ST     | 1773 |
| 100188 | 188  |
| 105057 | 1585 |

Bolt

2 BL10-3-B.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>AN960JD10L | Replacement | Mfg/<br>Purchased | Bin<br>No | Primary | Last | Route<br>200 | Unit of<br>Each | Qty on<br>3,459.000 | Remaining<br>2.0000 | Qty | Date | Status |
|----------------------------------|-------------|-------------------|-----------|---------|------|--------------|-----------------|---------------------|---------------------|-----|------|--------|
|                                  |             |                   |           |         |      |              |                 |                     |                     |     |      |        |

Washer



ALS7-1032-130



Insert



## Warehouse

### Location

Main Warehouse

|          |      |
|----------|------|
| ST       | 3459 |
| 101291   | 16   |
| 105793   | 49   |
| 110985 ✓ | 3394 |

Loc Qty

Loc Code

2 BL 10-3-10

## Warehouse

### Location

Main Warehouse

|        |       |     |
|--------|-------|-----|
| ST     | 10511 | 986 |
| 108606 | 52    |     |
| 111529 | 130   |     |
| 111779 | 34    |     |
| 112772 | 11    |     |
| 113238 | 759   |     |

Loc Qty

Loc Code

50 . BL 10-3-10.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev: O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>AN3C4A | Replacement | Mfg/<br>Purchased | Bin | Primary | Last | Route | Unit of<br>Each | Qty on<br>1,263.000 | Remaining<br>50.0000 | Qty | Date | Status |
|------------------------------|-------------|-------------------|-----|---------|------|-------|-----------------|---------------------|----------------------|-----|------|--------|
|                              |             |                   | No  |         |      | 200   |                 |                     |                      |     |      |        |



BOLT

Warehouse                    Loc Qty                    Loc Code

Location

Main Warehouse

|    |        |      |
|----|--------|------|
| ST | 14103  | 1263 |
|    | 112314 | 13   |
|    | 112720 | 12   |
|    | 112724 | 3    |
|    | 112829 | 1    |
|    | 112991 | 2    |
|    | 113121 | 64   |
|    | 113226 | 344  |
|    | 113422 | 124  |
|    | 113644 | 500  |
|    | 113749 | 200  |

50. BL10-3-10

AN960C10L



washer

Purchased                    No                    200                    Each                    388.0000                    50.0000



Warehouse                    Loc Qty                    Loc Code

Location

OFFSHORE

|    |        |     |
|----|--------|-----|
| FG | 113691 | 100 |
|    | 103585 | 100 |

Main Warehouse

|    |        |
|----|--------|
| ST | 288    |
|    | 112116 |
|    | 112612 |

50. BL10-3-0.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D3566-13 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | Primary<br>Last | Route<br>200 | Unit of<br>Each | Qty on<br>83.0000 | Remaining<br>1.0000 | Qty | Date | Status |
|--------------------------------|-----------------------|----------------------|-----------|-----------------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
|                                |                       |                      |           |                 |              |                 |                   |                     |     |      |        |

| Component Item ID/<br>D3566-13 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|--------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                                |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                                |                       |                      |           | FP               |                | 81      |          |      |        |
|                                |                       |                      |           | 53461 ✓          |                | 81      |          |      |        |

| Component Item ID/<br>D3566-5 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|-------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                               |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                               |                       |                      |           | ST               |                | 2       |          |      |        |
|                               |                       |                      |           | 45717            |                | 1       |          |      |        |

| Component Item ID/<br>D3566-5 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|-------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                               |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                               |                       |                      |           | ST               |                | 2       |          |      |        |
|                               |                       |                      |           | 50265            |                | 1       |          |      |        |

| Component Item ID/<br>D3566-5 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|-------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                               |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                               |                       |                      |           | ST               |                | 4       |          |      |        |
|                               |                       |                      |           | 36113            |                | 1       |          |      |        |

| Component Item ID/<br>D3566-5 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|-------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                               |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                               |                       |                      |           | ST               |                | 4       |          |      |        |
|                               |                       |                      |           | 46186            |                | 1       |          |      |        |

| Component Item ID/<br>D3566-5 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|-------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                               |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                               |                       |                      |           | ST               |                | 4       |          |      |        |
|                               |                       |                      |           | 47318            |                | 1       |          |      |        |

| Component Item ID/<br>D3566-5 | Replacement<br>Gasket | Mfg/<br>Manufactured | Bin<br>No | <u>Warehouse</u> |                | Loc Qty | Loc Code | Date | Status |
|-------------------------------|-----------------------|----------------------|-----------|------------------|----------------|---------|----------|------|--------|
|                               |                       |                      |           | <u>Location</u>  | Main Warehouse |         |          |      |        |
|                               |                       |                      |           | ST               |                | 4       |          |      |        |
|                               |                       |                      |           | 51260            |                | 1       |          |      |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>D3566-1 | Replacement | Mfg/<br>Manufactured | Bin | Primary<br>No | Last | Route<br>200 | Unit of<br>Each | Qty on<br>39.0000 | Remaining<br>2.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----|---------------|------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
|                               |             |                      |     |               |      |              |                 |                   |                     |     |      |        |

Gasket

| Component Item ID/<br>D3564-11 | Replacement | Mfg/<br>Manufactured | Bin | Primary<br>No | Last | Route<br>200 | Unit of<br>Each | Qty on<br>5.0000 | Remaining<br>1.0000 | Qty | <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--------------------------------|-------------|----------------------|-----|---------------|------|--------------|-----------------|------------------|---------------------|-----|------------------|----------------|-----------------|
|                                |             |                      |     |               |      |              |                 |                  |                     |     | <u>Location</u>  |                |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | FP               | 56532          | 34              |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 52512            | 3              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 54480            | 1              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 55011            | 3              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 55320            | 27             |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | Main Warehouse   |                |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | ST               | 5              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 46349            | 1              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 51218            | 1              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 51259            | 3              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     |                  |                |                 |

Wearshoe

| Component Item ID/<br>D3564-11 | Replacement | Mfg/<br>Manufactured | Bin | Primary<br>No | Last | Route<br>200 | Unit of<br>Each | Qty on<br>5.0000 | Remaining<br>1.0000 | Qty | <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--------------------------------|-------------|----------------------|-----|---------------|------|--------------|-----------------|------------------|---------------------|-----|------------------|----------------|-----------------|
|                                |             |                      |     |               |      |              |                 |                  |                     |     | <u>Location</u>  |                |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | FP19             | 55332          | 3               |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 52125            | 3              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | Main Warehouse   |                |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | ST               | 2              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 45823            | 1              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     | 50112            | 1              |                 |
|                                |             |                      |     |               |      |              |                 |                  |                     |     |                  |                |                 |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>D3564-13 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary | Last | Route<br>200 | Unit of<br>Each | Qty on<br>23.0000 | Remaining<br>1.0000 | Qty | Date | Status |
|--------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
|                                |             |                      |           |         |      |              |                 |                   |                     |     |      |        |

Wearshoe

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

FP17 56285  
51611

11

11

Main Warehouse

ST  
45409  
46495

12

2

10

D3564-9



Manufactured

No

200

Each

14.0000

1.0000

Wearshoe

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

FP19  
55025 ✓

12

12

Main Warehouse

ST  
44659  
45825

2

1

1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D3564-5 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary | Last | Route<br>200 | Unit of<br>Each | Qty on<br>44.0000 | Remaining<br>1.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
|                               |             |                      |           |         |      |              |                 |                   |                     |     |      |        |

Wearshoe



| Warehouse<br><u>Location</u> | Loc Qty | Loc Code |
|------------------------------|---------|----------|
| OFFSHORE<br>FG <u>24770</u>  | 2       |          |
| 34806                        | 2       |          |
| Main Warehouse               |         |          |
| FP19                         | 40      |          |
| 51925                        | 1       |          |
| 54772 ✓                      | 13      |          |
| 55024                        | 12      |          |
| 55333                        | 14      |          |
| Main Warehouse               |         |          |
| ST                           | 2       |          |
| 45824                        | 1       |          |
| 47433                        | 1       |          |

1 Br 10-3-10.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Picklist Print

Page 10

February 10, 2010 2:55:59 PM

Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D2594-3 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary<br>Last | Route<br>200 | Unit of<br>Each | Qty on<br>668.0000 | Remaining<br>16.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|-----------------|--------------|-----------------|--------------------|----------------------|-----|------|--------|
|                               |             |                      |           |                 |              |                 |                    |                      |     |      |        |

O-Ring, 205 Skidtube



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| FP               | 527            |                 |
| 51613 ✓          | 27             |                 |
| 55546 ✓          | 500            |                 |
| Main Warehouse   |                |                 |
| ST               | 141            |                 |
| 52562            | 141            |                 |

16-BR10-3-10.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Picklist Print

Page 11

February 10, 2010 2:55:59 PM

Work Order ID: 56134



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/<br>D2594-1 | Replacement | Mfg/<br>Manufactured | Bin<br>No | Primary | Last | Route<br>200 | Unit of<br>Each | Qty on<br>705.0000 | Remaining<br>16.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|--------------------|----------------------|-----|------|--------|
| Plug, 205 Skidtube            |             |                      |           |         |      |              |                 |                    |                      |     |      |        |

|                | <u>Warehouse</u><br><u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|----------------|-------------------------------------|----------------|-----------------|
| Main Warehouse |                                     |                |                 |
|                | FP                                  | 577            |                 |
|                | 54008                               | 1              |                 |
|                | 54643                               | 15             |                 |
|                | 55002 ✓                             | 561            |                 |
| Main Warehouse |                                     |                |                 |
|                | ST                                  | 128            |                 |
|                | 42221                               | 16             |                 |
|                | 42807                               | 92             |                 |
|                | 43884                               | 3              |                 |
|                | 46435                               | 2              |                 |
|                | 51527                               | 9              |                 |
|                | 51757                               | 6              |                 |

16.02.10-3-10.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA          |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2580                                       | REV. D<br>SHEET 1 OF 3 |
| DATE<br>07.02.27              |                                | TITLE<br>205 SKIDTUBE ASSEMBLY                             | SCALE<br>NTS           |
| A                             | 96.09.16                       | NEW ISSUE  |                        |
| B                             | 96.12.02                       | AS MANUFACTURED  |                        |
| C                             | 98.08.26                       | REDRAWN, INCLUDED DEO 9094/9097                            |                        |
| D                             | 07.02.27                       | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 |                        |

**RELEASED**  
07.06.28 *[Signature]*

| QTY<br>-041 | QTY<br>-045 | Part Number   | Description       |
|-------------|-------------|---|-------------------|
| X           |             | D2580-041   | SKIDTUBE ASSEMBLY |
|             | X           | D2580-045   | SKIDTUBE ASSEMBLY |
| 1           | 1           | D2500-1-190   | EXTRUSION         |
| 1           | 1           | D2576-3   | STEP              |
| 20          | 24          | D2579   | CROSS BOLT SPACER |
| 16          | 16          | D2594-1   | PLUG              |
| 16          | 16          | D2594-3   | O-RING            |
| 1           | 1           | D2596   | 205 WEB           |
| 1           | 1           | D2855   | AFT CAP           |
| 1           | 1           | D3564-5   | WEARSHOE          |
| 1           | 1           | D3564-9   | WEARSHOE          |
| 1           | 1           | D3564-11  | WEARSHOE          |
| 1           | 1           | D3564-13  | WEARSHOE          |
| 2           | 2           | D3566-1   | GASKET            |
| 1           | 1           | D3566-5   | GASKET            |
| 1           | 1           | D3566-13  | GASKET            |
| 50          | 50          | ALS7-1032-130<br>or AKS7-1032-130<br>or AKS4-1032-130<br>or AELS-1032-130 | INSERT            |
| 50          | 50          | AN3C4A  | BOLT              |
| 2           | 2           | AN3-5A  | BOLT              |
| 50          | 50          | AN960C10L   | WASHER            |
| 2           | 2           | AN960JD10L  | WASHER            |

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *56139*  
*BJ 10-210*

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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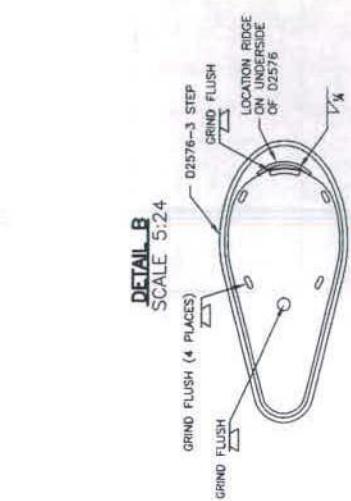
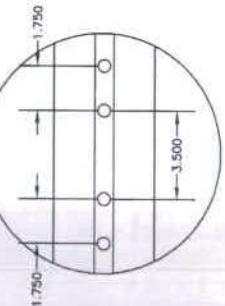
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

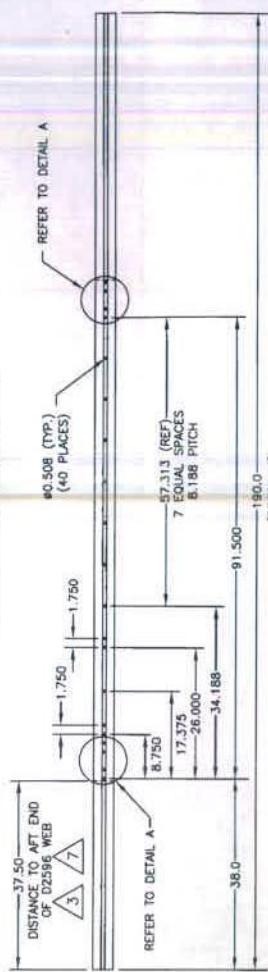
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**RELEASED**  
07/26/04

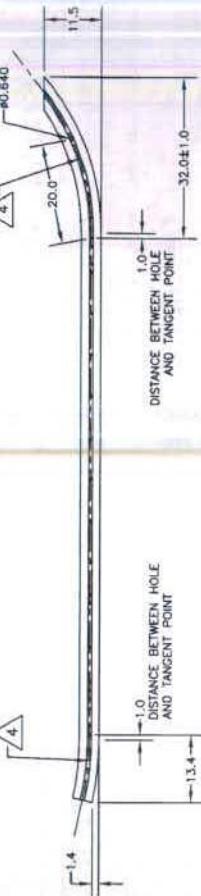


D2580-1 DRILLING DETAIL



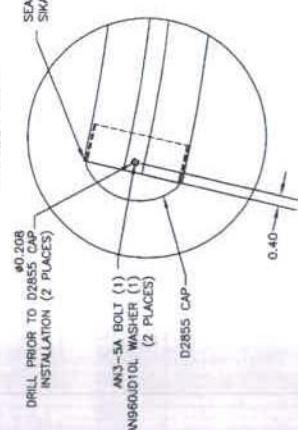
**RELEASED**  
07/26/04

D2580-1 BENDING AND CUTTING DETAIL



DETAIL C  
SCALE 5:24

SEAL WITH  
SIKAFLUX-241/-291



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT 02579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C BORE 02579 SPACER TO #0.437 X 1.00 DEEP

AN96001OL WASHER (1)  
(50 PLACES)

D2580-041 NOTES

1) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.35.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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**DART**

DART AEROSPACE LTD.

SPACERWAY, ONTARIO, CANADA

REV. 0

DRAWING NO.

D2580

SHEET 2 OF 3

SCALE

1:24

**DART**

DART AEROSPACE LTD.

SPACERWAY, ONTARIO, CANADA

REV. 0

DRAWING NO.

D2580

SHEET 2 OF 3

SCALE

1:24

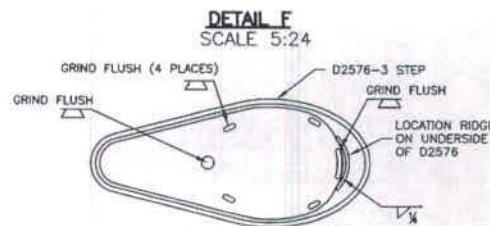
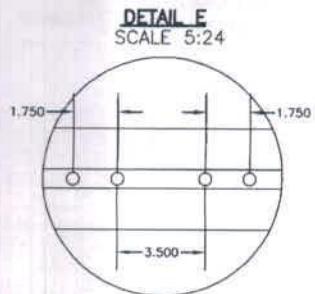
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

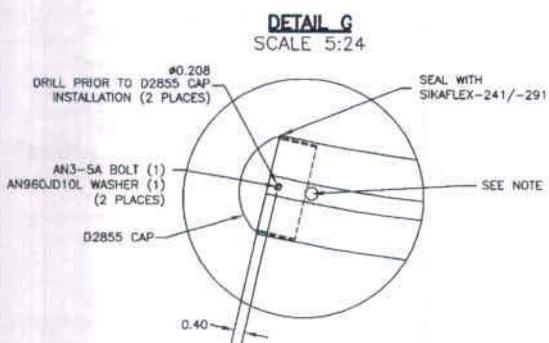
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

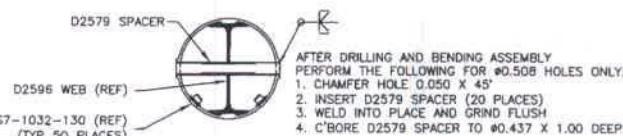
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07-06-28



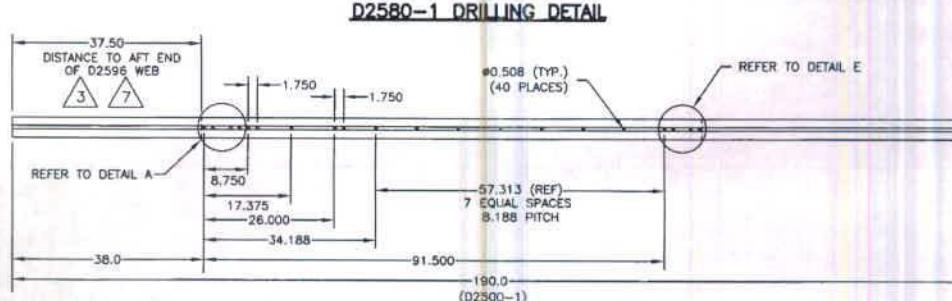
**SECTION H-H**  
SCALE 5:24



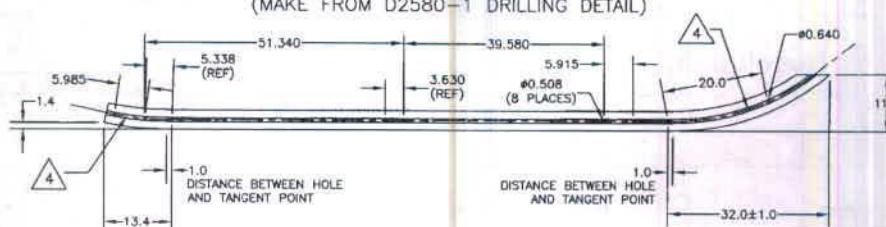
5

**D2580-045 NOTES**

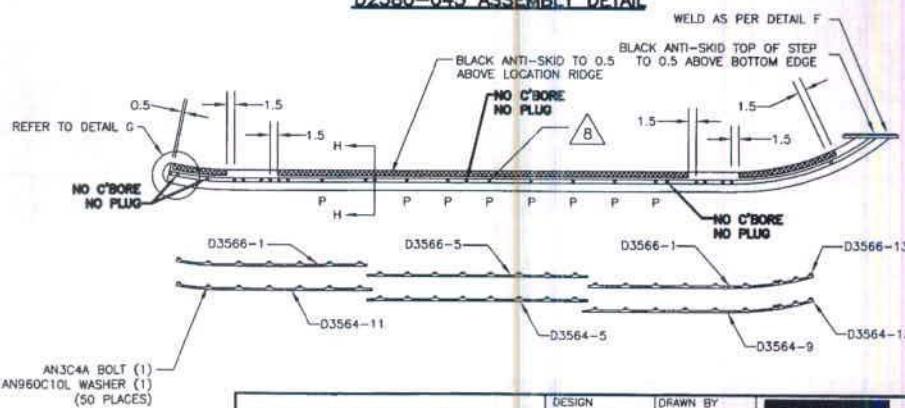
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(50 PLACES)

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|------------------|--------------------------------|------|--|
| P4               | P4                             |      | REV. 0   |
| CHECKED          | APPROVED                       | H    | DRAWING NO.<br>D2580                               |
| DATE<br>07.02.27 | TITLE<br>205 SKIDTUBE ASSEMBLY |      | SCALE<br>1:24                                      |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 56134  
Part number: D205 634.041  
Description: 205 skid tube  
Welding Process: Tig[] Mig[]  
Base material: Aluminum  
Current: AC[] DC[]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[] fail[]  
Penetration: pass[] fail[]

**UNACCEPTABLE**

Cracks: pass[] fail[]  
Undercut: pass[] fail[]  
Pin holes: pass[] fail[]  
Overlap (cold lap) pass[] fail[]  
Porosity (surface): pass[] fail[]  
Coloration: pass[] fail[]

Qualifier B. D. E. Date of Test Coupon 10-02-23

Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

